

Date: Monday, 1/16/2006 4:18:54 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT WELDMENT ASS'Y
Job Number :	25519	Part Number :	D34431
Estimate Number :	10554	Drawing Number :	D3443 REV. <i>XB</i>
P.O. Number :	<i>N/A</i>	Project Number :	N/A
This Issue :	1/16/2006	Drawing Revision :	<i>XB</i>
Prsht Rev. :	NC	Material :	<i>N/A</i>
First Issue :	<i>N/A</i>	Due Date :	1/23/2006
Previous Run :	24938	Qty:	1
	Type : MACHINED PARTS	Um:	Each
Written By :	<i>SEE COMMENT BELOW</i>		
Checked & Approved By :	<i>SEE COMMENT BELOW</i>		
Comment :	A 05.11.14 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B2500X1250	17-4 SS BAR
-----	----------------	-------------



Comment: Qty.: 0.2100 f(s)/Unit Total: 0.2100 f(s)
 Material: 17-4 SS Bar 2.500" X 1.250"
 (M17-4-B2.500x01.250)
 Batch: *M 18 744 5 06/01/26*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank 2.400 " long

5 06/01/26 x1

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA587 Rev: *A* & Dwg D3443 Rev: *B*

5 06/01/27 x1 PTD.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5 06/01/07 x1

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 06.01.27 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 6/27/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
dd/1/27	#	one part SCRAP (first run)	<i>[Signature]</i>	SCRAP destroy and replace	Ep 06/1/27	<i>[Signature]</i>	<i>[Signature]</i>	6.01.31
	3.0	one part SCRAP. wasn't paying attention to foto.	<i>[Signature]</i>	SCRAP, destroy and replace (Pay more attention.)	Ep 06/1/27			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:18:55 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 25519

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Tumble & deburr per dwg D3443

N/A 206-01-31

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St

P.O. 6/2/01

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/01

(1)

17 06/02/01

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25519
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	± 0.010	1.003	✓			
0.342	$\begin{matrix} +0.000 \\ -0.005 \end{matrix}$	0.340	✓			
0.329	± 0.010	0.333	✓			
0.500	$\begin{matrix} +0.000 \\ -0.005 \end{matrix}$	0.499	✓			
2.23	± 0.030	2.225	✓			
0.95	± 0.030	0.939	✓			
0.229	± 0.010	0.235	✓			
0.128	$\begin{matrix} \pm 0.005 \\ \pm 0.001 \end{matrix}$	0.129	✓			
2.21	± 0.030	2.216	✓			
0.656	$\begin{matrix} +0.000 \\ -0.001 \end{matrix}$	0.655	✓			
1.048	± 0.010	1.045	✓			
0.524	± 0.010	0.526	✓			
0.525	± 0.010	0.525	✓			
R 0.125	± 0.010	0.125	✓		R.g	
R. 350	± 0.010	0.350	✓		R.g	
0.05 x 45°	± 0.030	0.05 x 45°	✓			
R. 0.032	± 0.010	0.032	✓		Radium gauge	
0.470	± 0.010	0.468	✓			
0.165	± 0.020	0.166	✓			
1/4-28 UNF2B	w/A	1/4-28	✓			

Measured by:	ep	Audited by:	J.L	Prototype Approval:	
Date:	06/01/27	Date:	06.01.27	Date:	

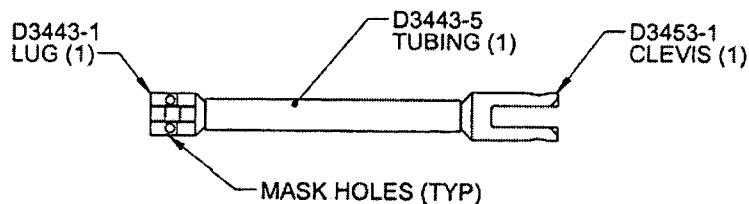
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED

05.12.09 #

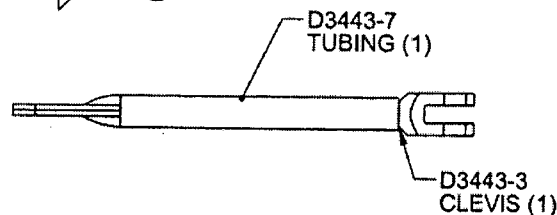


PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

8.54

INSTALL SPAENAU P/N 238-805 DOWEL PIN
(TYP)

0.10
(TYP)

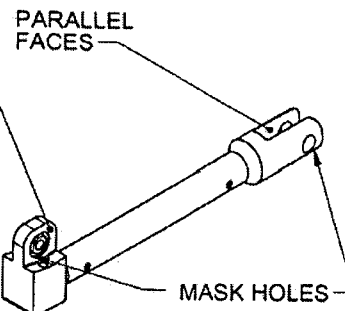


INSTALL SPAENAU P/N 238-805
DOWEL PIN

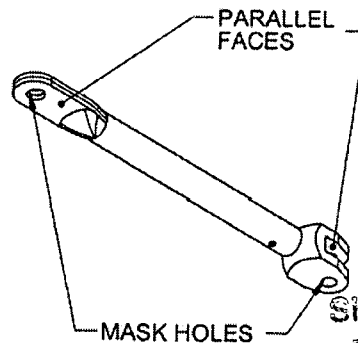
0.10

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D3443-041



D3443-043



SUBJECT TO AMENDMENT
WITH INSTRUCTIONS

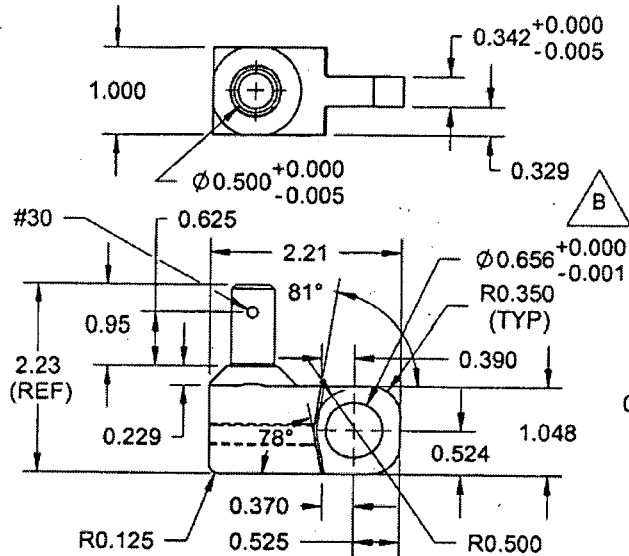
WORK

NO 25519

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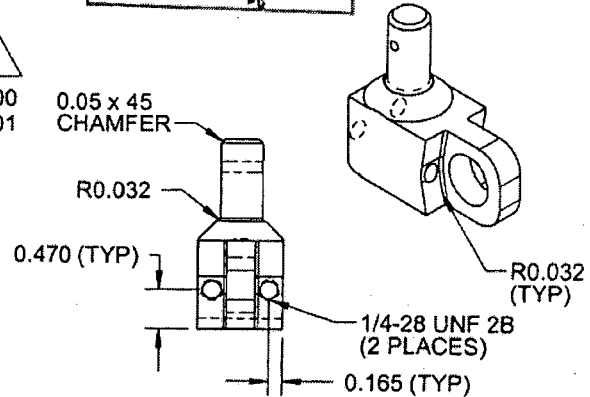
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2	



RELEASED

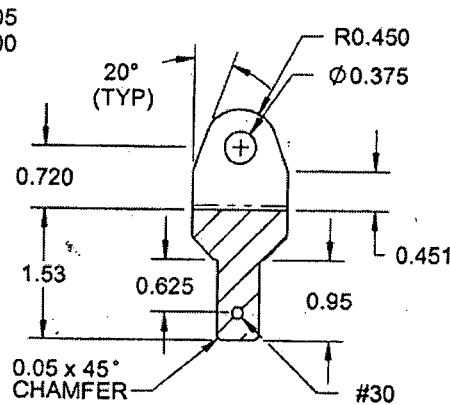
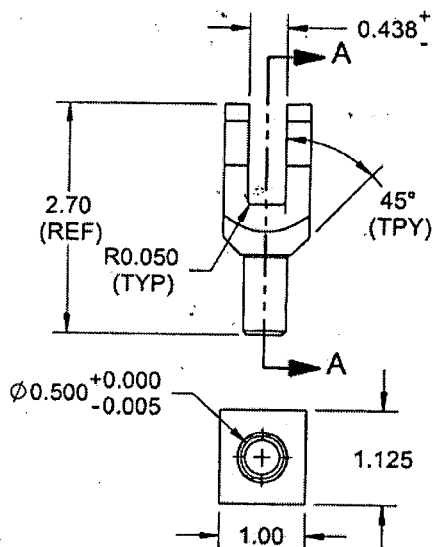
05.12.09



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010



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25519

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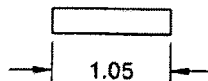
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

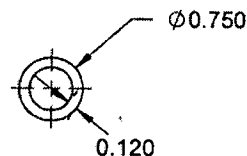
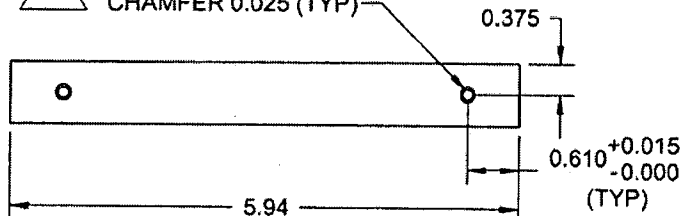
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.05

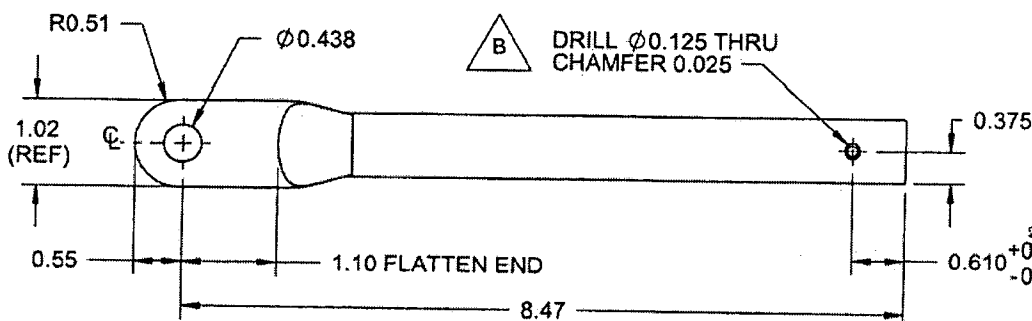
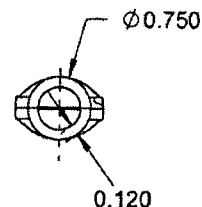


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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